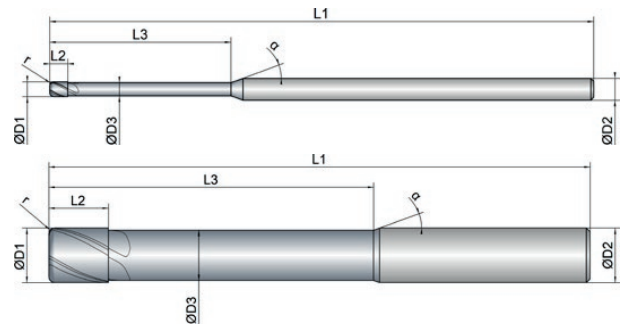


Cooling	
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	HSC	HPC	
Application			
Features	HA	≠	



- Unequal tooth pitch and variable helical pitch for smooth running
 - Specially designed cutting edge geometry for contour machining
 - Optimized chip chambers for safe evacuation of the chips
-
- For roughing and finishing
 - Long version for deeper cavities
-
- Radius tolerance $r \leq 1.5 \text{ mm}$: $\pm 0.003 \text{ mm}$
 - Radius tolerance $r > 1.5 \text{ mm}$: $\pm 0.005 \text{ mm}$



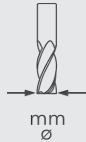
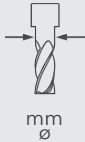

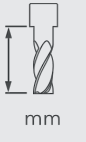






Roughing



Finishing



EXPK1-M06-0113	D1 mm ∅	D3 mm ∅	L2 mm	L3 mm	L1 mm	D2 mm ∅	z #	r mm	 °	α °
1/0,2	1.0	0.85	1.5	20.0	75.0	3.0	4	0.20	30	20
2/0,2	2.0	1.8	2.5	25.0	75.0	3.0	4	0.20	30	20
2/0,5	2.0	1.8	2.5	25.0	75.0	3.0	4	0.50	30	20
3/0,3	3.0	2.7	4.0	32.0	75.0	3.0	4	0.30	30	20
3/0,5	3.0	2.7	4.0	32.0	75.0	3.0	4	0.50	30	20
3/1	3.0	2.7	4.0	32.0	75.0	3.0	4	1.00	30	20
4/0,5	4.0	3.7	5.0	36.0	75.0	4.0	4	0.50	30	20
4/1	4.0	3.7	5.0	36.0	75.0	4.0	4	1.00	30	20
6/0,5	6.0	5.5	7.0	44.0	83.0	6.0	4	0.50	30	20
6/1	6.0	5.5	7.0	44.0	83.0	6.0	4	1.00	30	20

EXPK1-M06-0113	D1	D3	L2	L3	L1	D2	z	r		α
	 mm ∅	 mm ∅	 mm	 mm	 mm	 mm ∅	 #	 mm	 °	 °
8/0,5	8.0	7.4	9.0	54.0	100.0	8.0	4	0.50	30	20
8/1	8.0	7.4	9.0	54.0	100.0	8.0	4	1.00	30	20
8/2	8.0	7.4	9.0	54.0	100.0	8.0	4	2.00	30	20
10/0,5	10.0	9.2	11.0	60.0	100.0	10.0	4	0.50	30	20
10/1	10.0	9.2	11.0	60.0	100.0	10.0	4	1.00	30	20
10/2	10.0	9.2	11.0	60.0	100.0	10.0	4	2.00	30	20
12/0,5	12.0	11.0	12.0	75.0	119.0	12.0	4	0.50	30	20
12/1	12.0	11.0	12.0	75.0	119.0	12.0	4	1.00	30	20
12/2	12.0	11.0	12.0	75.0	119.0	12.0	4	2.00	30	20
16/1	16.0	15.0	16.0	92.0	150.0	16.0	4	1.00	30	20
16/2	16.0	15.0	16.0	92.0	150.0	16.0	4	2.00	30	20
20/1	20.0	18.5	20.0	92.0	150.0	20.0	4	1.00	30	20



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Material	Strength (N/mm ²)	Dimension	Infeed in mm	Application	Ø1		Ø2		Ø3		Ø4		Ø6		Ø8	
					ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz
			Vc (m/min)													
P																
1.1	Steel, unalloyed	<500	130	0.012	0.015	0.015	0.018	0.018	0.02	0.02	0.022	0.027	0.032	0.034	0.039	
1.2-1.5	Steel, unalloyed	<1100	100	0.01	0.012	0.012	0.015	0.015	0.018	0.018	0.02	0.024	0.03	0.032	0.037	
2.1-2.2	Steel, low-alloyed	<950	95	0.01	0.012	0.012	0.015	0.015	0.018	0.018	0.02	0.024	0.03	0.032	0.037	
2.3-2.4	Steel, low-alloyed	<1300	85	0.008	0.01	0.01	0.012	0.012	0.015	0.015	0.018	0.022	0.027	0.029	0.034	
3.1-3.2	Steel, high-alloyed	<1100	90	0.008	0.01	0.01	0.012	0.012	0.015	0.015	0.018	0.022	0.027	0.029	0.034	
3.3	Steel, high-alloyed	<1400	75	0.005	0.008	0.008	0.01	0.01	0.012	0.012	0.015	0.02	0.024	0.027	0.032	

			Vc (m/min)													
K																
1.1-1.2	Grey cast iron	<1000	120	0.01	0.012	0.012	0.015	0.015	0.018	0.018	0.02	0.022	0.027	0.029	0.034	
2.1-2.2	Modular cast iron	<850	90	0.008	0.01	0.01	0.012	0.012	0.015	0.015	0.018	0.02	0.024	0.027	0.032	
3.1-3.2	Malleable cast iron	<800	85	0.008	0.01	0.01	0.012	0.012	0.015	0.015	0.018	0.02	0.024	0.027	0.032	

			Vc (m/min)													
M																
1.1	Inox, ferritic/martensitic	<850	75	0.008	0.01	0.01	0.012	0.012	0.015	0.015	0.018	0.022	0.027	0.029	0.034	
2.1	Inox, austenitic	<650	65	0.007	0.008	0.008	0.01	0.01	0.012	0.012	0.015	0.02	0.024	0.027	0.03	
2.2	Inox, austenitic	<750	55	0.005	0.006	0.006	0.008	0.008	0.01	0.01	0.012	0.018	0.022	0.024	0.026	
3.1	Duplex steel	<1100														

Material	Strength (N/mm ²)	Dimension	Infeed in mm	Application	Ø10		Ø12		Ø16		Ø20					
					ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.2xD ap=1xD	ae=0.04xD ap=0.04xD				
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz					
			Vc (m/min)													
P																
1.1	Steel, unalloyed	<500	130	0.043	0.048	0.053	0.058	0.065	0.075	0.075	0.09					
1.2-1.5	Steel, unalloyed	<1100	100	0.04	0.045	0.05	0.055	0.06	0.07	0.07	0.085					
2.1-2.2	Steel, low-alloyed	<950	95	0.04	0.045	0.05	0.055	0.06	0.07	0.07	0.085					
2.3-2.4	Steel, low-alloyed	<1300	85	0.038	0.042	0.048	0.053	0.058	0.068	0.068	0.083					
3.1-3.2	Steel, high-alloyed	<1100	90	0.038	0.042	0.048	0.053	0.058	0.068	0.068	0.083					
3.3	Steel, high-alloyed	<1400	75	0.035	0.04	0.045	0.05	0.055	0.065	0.065	0.08					

			Vc (m/min)													
K																
1.1-1.2	Grey cast iron	<1000	120	0.038	0.042	0.048	0.053	0.058	0.068	0.068	0.083					
2.1-2.2	Modular cast iron	<850	90	0.035	0.04	0.045	0.05	0.055	0.065	0.065	0.08					
3.1-3.2	Malleable cast iron	<800	85	0.035	0.04	0.045	0.05	0.055	0.065	0.065	0.08					

			Vc (m/min)													
M																
1.1	Inox, ferritic/martensitic	<850	75	0.038	0.042	0.048	0.053	0.058	0.068	0.068	0.083					
2.1	Inox, austenitic	<650	65	0.034	0.038	0.043	0.048	0.053	0.063	0.063	0.078					
2.2	Inox, austenitic	<750	55	0.03	0.034	0.038	0.043	0.048	0.058	0.058	0.073					
3.1	Duplex steel	<1100														

NOTE | The values marked in turquoise are side applications! By using multipass milling the maximum infeed (ae, ap) is 0.5xcorner radius!